

Work Order ID 92088-2

October-23-12 10:34:24 AM

92088

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Item ID: D2282-041

Revision ID:

Item Name: T Assembly

Start Date: 23/10/2012 Start Qty: 50.00

Required Date: 06/11/2012 Req'd Qty: 50.00

Reference:

Accept

N9000040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals:

Process Plan: HLT

Date: 12-10-23

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2282	Rev E								

100

100

Large Fab

Large Fab

Large Fab

0.00

Memo

0.00

1-Weld as per D2282-041 'T' Handle Assembly
Grind chamfers and ensure full penetration as per dwg D2282
*****brush weld right after welding, to take color off *****
A/RER316L SS Filling Rod

m/26048

③ me 13-06-27

110

110

QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

③ B.06-27

DAS
09
2-88

120

120

Small Fab

Small Fab

Small Fab

0.00

Memo

Tumble

0.00

30 NG 13-7-4

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Item ID: D2282-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: T Assembly

Start Date: 23/10/2012 Start Qty: 50.00

50

Cust Item ID:

Required Date: 06/11/2012 Req'd Qty: 50.00

50

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				30			DA 05 B-07-05
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: G.A Memo	0.00 0.00				30x			13/07/09
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							13/7/10

W 1307-10

Picklist Print

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T

Work Order ID: 92088

92088

Parent Item: D2282-041

D2282-041

Parent Item Name: T Assembly

Start Date: 23/10/2012

Required Date: 06/11/2012

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP Rev:A Removed from 9 Digit 05-12-02 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2282-3		Manufactured	No			100	Each	46.0000	1	50			
										**	(+30) 412		

D2282-3
Tube

★ B99026 +30

Location	Loc Qty	Loc Code
WA	35	
74969	11	

D2282-5		Manufactured	No			100	Each	12.0000	1	50			
										**	(+30) 412		

D2282-5
Tube

★ B91850 + 8
B92093 +22

Location	Loc Qty	Loc Code
WA		
WA020	11	
74962	11	

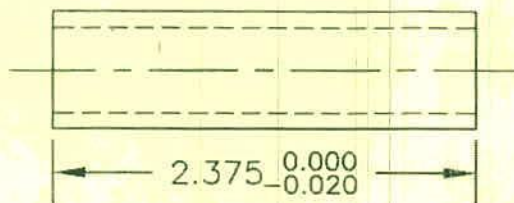
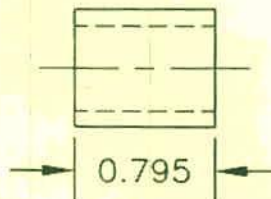
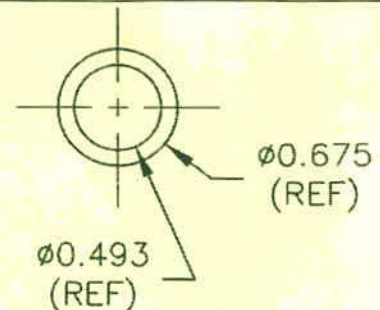
10/15/20

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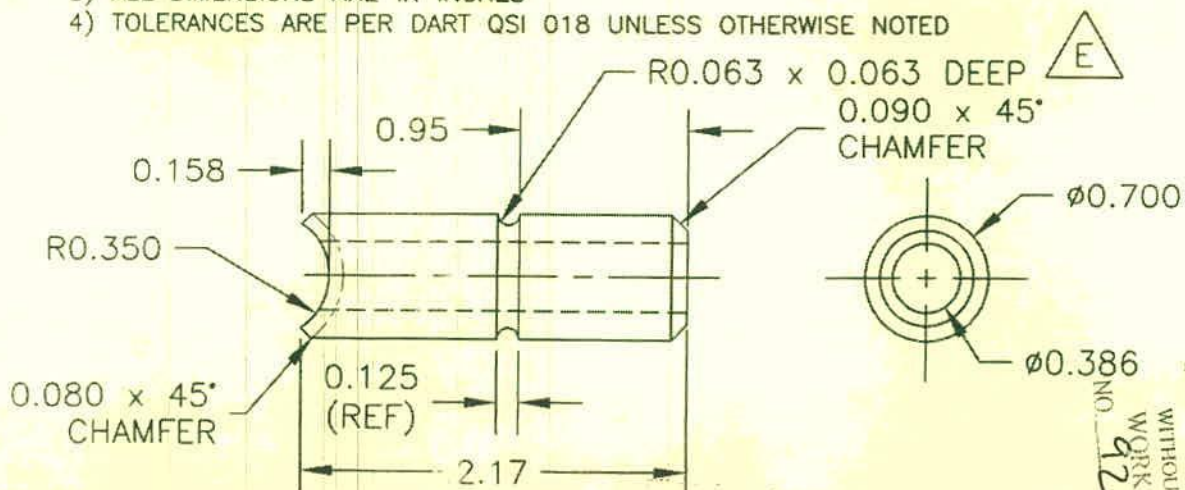
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DARTRELEASED
05/09/16

DESIGN BW	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07	TITLE HANDLE TUBES		SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	

**D2282-3****D2282-7****D2282-3/-7 TUBE:**

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D2282-5****D2282-5 STEM:**

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

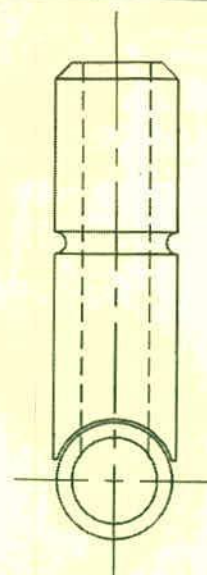
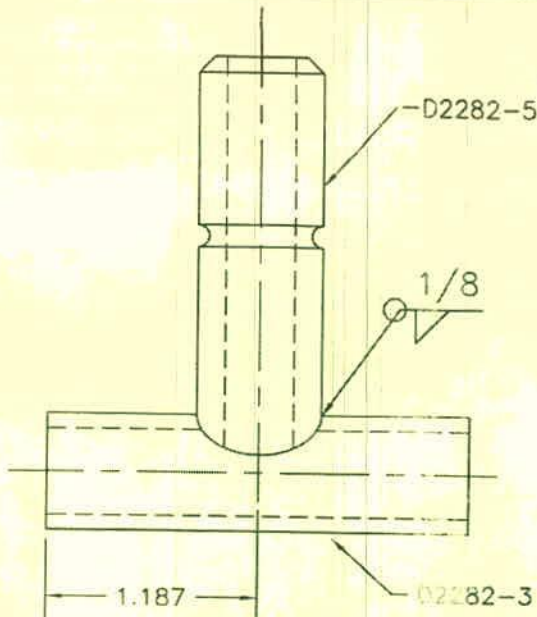
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NO. 92088 MLS
12-10-23
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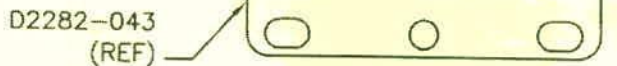
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DATE 05.06.07	TITLE HANDLE TUBES		SCALE 1:1

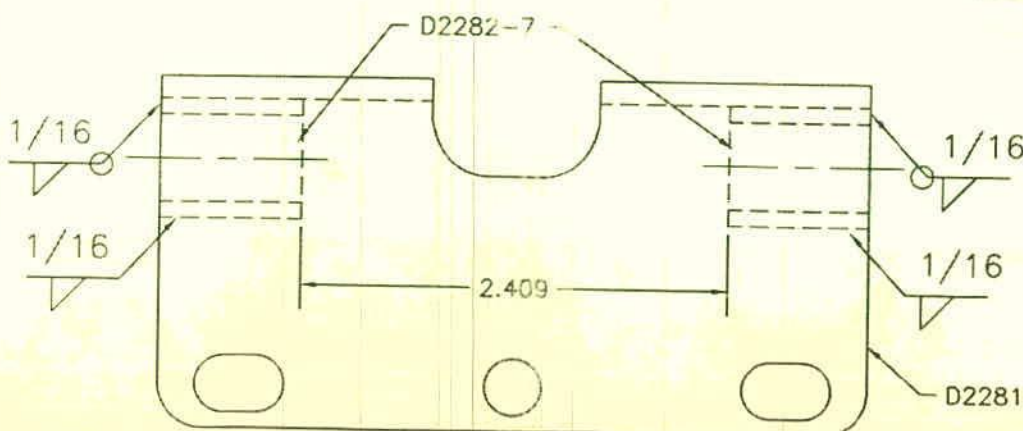
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05/09/16

D2282-041 'T' ASSEMBLY
WELD ASSEMBLY PER DART QSI 004



GENERAL ASSEMBLY
SCALE 1:2



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

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